







Date: Wednesday, 6/27/2007 1:08:31 PM  
User: Kim Johnston



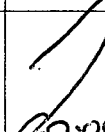
# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 33224	
Estimate Number : 10791	
P.O. Number : N/A	Part Number : D3282041
This Issue : 6/27/2007 S.O. No. : N/A	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 32405	Material : N/A
Written By : <u>                    </u>	Due Date : 7/12/2007
Checked & Approved By : <u>                    </u>	Qty: 4 Um: Each
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	
Additional Product	
Job Number: 	
Seq. #	Machine Or Operation: Description :
1.0	D2792130 EXTRUSION
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2792-130 Extrusion <u>B-33518</u> <del>221</del> Identify as D3282-1	
2.0	LANDING GEAR 1 LANDING GEAR RESOURCE 1
	
Comment: LANDING GEAR RESOURCE 1 Cut to length as per Dwg D3282. <u>AWM 07/08/15</u>	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA579 & Dwg D3282 2-Deburr <u>J.F. 07/08/22</u>	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.F. 07/08/22</u>	
5.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>J.F. 07/08/22</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/21

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-21	3.0	1 part scrap. Material is twisted upon total length. R.C: Material twisted from stripping bundle & transport.	 07/08/21	Scrap & replace. Quarantine, <del>to</del> not destroy.	S.F. 07.08.21	Er 07/08/21	 07/08/21	 07-08-21

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33224

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-8-23

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7-8-23

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number  
2 D3283-1

Description  
Doubler

Batch

B32477  
B33717

7-8-23

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 228.0000 Each(s)

Pick:

Qty Part Number  
57 MS20470AD4-7

Description  
Rivet

Batch

M104291

228

7-8-23

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web  
A/RN/ALPS-3 M103674

7-8-23 (4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-8-24 (4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: LG

7-8-24

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33224

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



4

Comment: FINAL INSPECTION/W/O RELEASE

200708/24

Job Completion



h 07-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

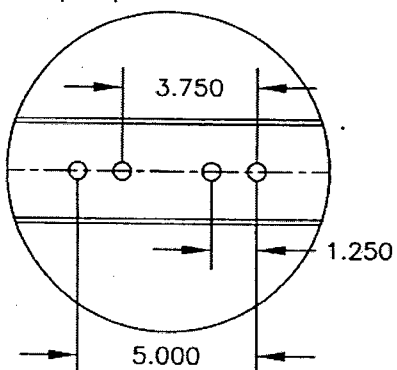
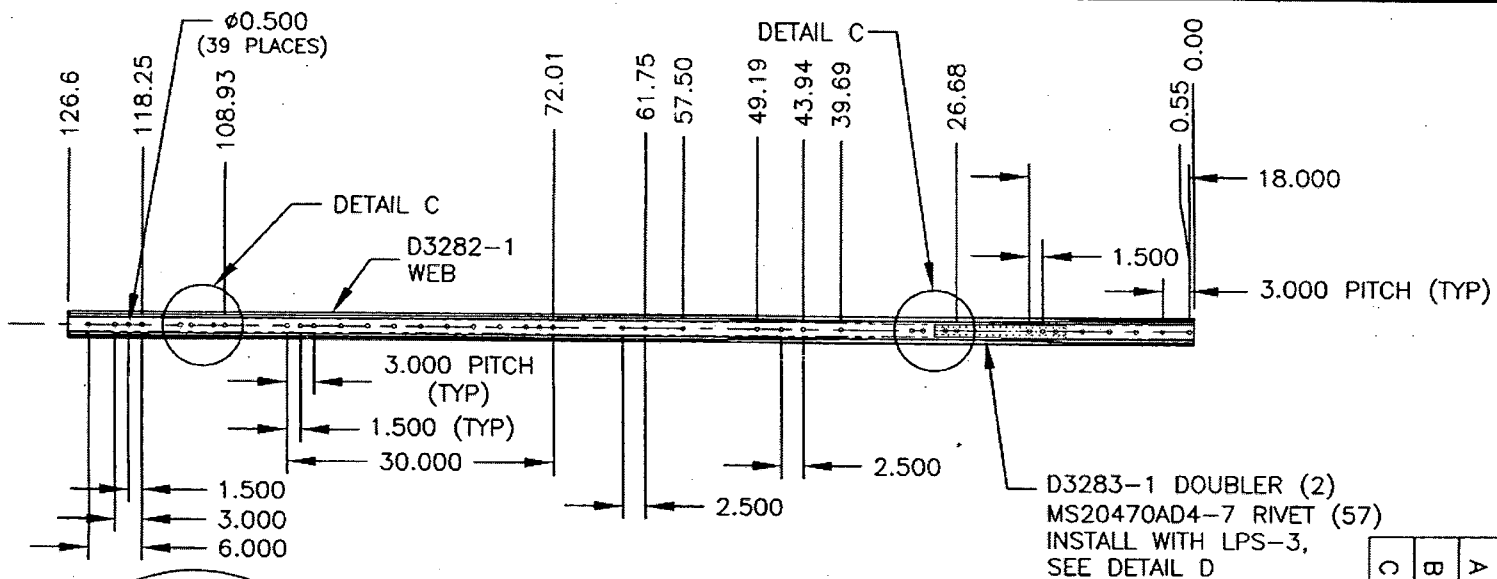
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

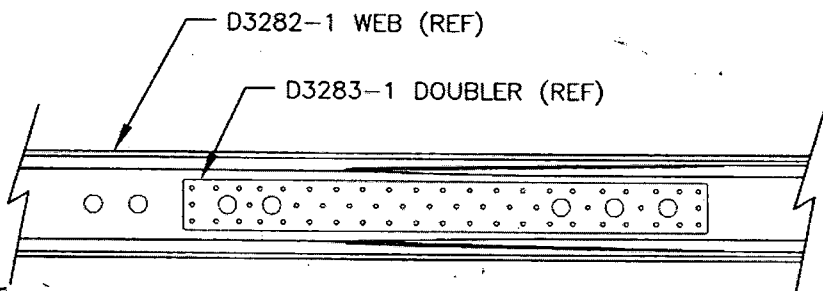
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D3282	SHEET 1 OF 2
DATE			TITLE	SCALE	
05.08.09			FLOAT WEB, 206L/407	1:20	
A		04.05.05	NEW ISSUE		
B		05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C		05.08.09	REMOVE D3390-1, NOW MACHINED		



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

RELEASED

05-09-12

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED C  
SUBJECT TO A/E/AS  
WITHOUT NOTICE  
WORK ORDER  
NO. 33224

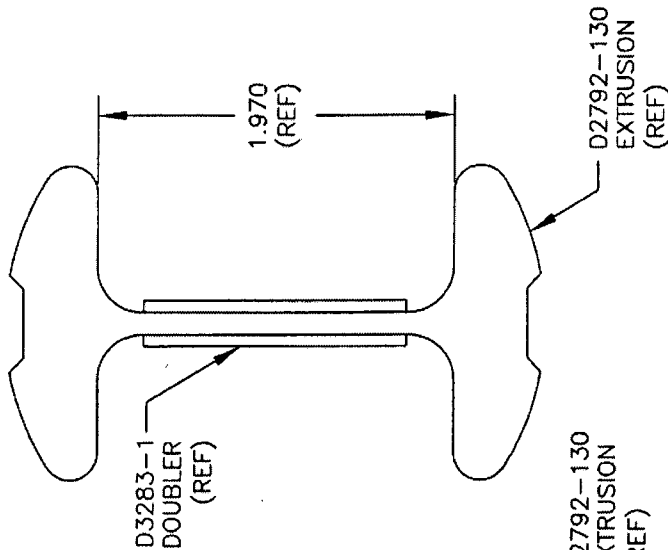
**Copyright © 2004 by DART AEROSPACE USA, INC.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

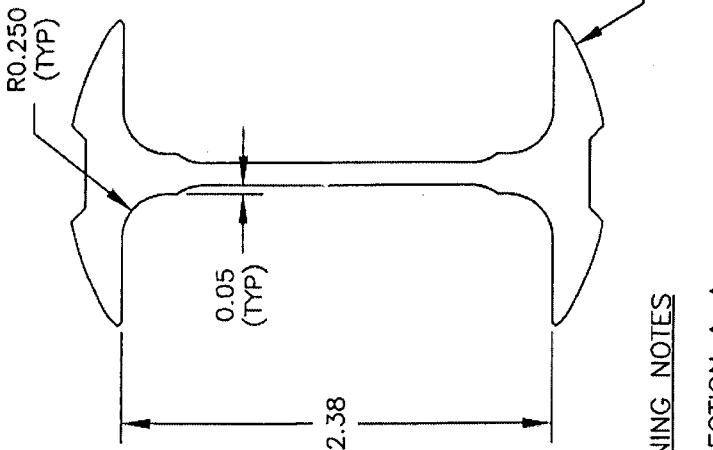


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3282	REV. C SHEET 2 OF 2
DATE 05.08.09	TITLE FLOAT WEB, 206L/407		SCALE 1:20

### SECTION B-B



### SECTION A-A



#### D3282-1 MACHINING NOTES

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

3 UNIFORM SECTION B-B

4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A  
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,  
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A

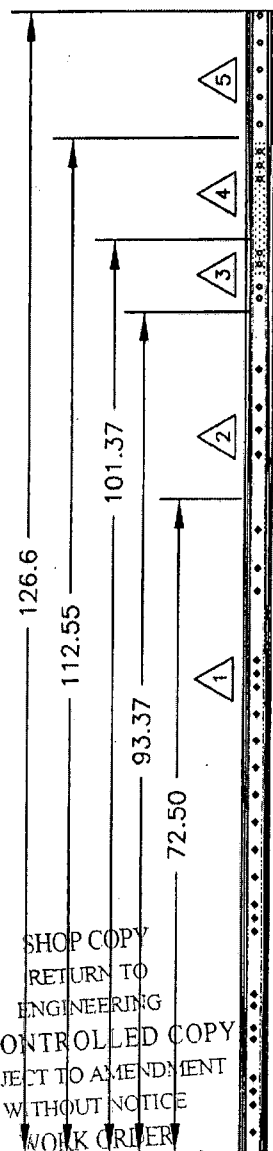
6 81.000 BETWEEN SECTIONS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 33224

RELEASED

05-09-12 #



Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

33224

DART AEROSPACE LTD		Work Order: 33877
Description: Float web		Part Number: 03282-1
Inspection Dwg: 03282 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A .050"	±.030"	.040"	✓			
B 2.38"	±.030"	2.376"	✓			
C R 0.250"	±.010"	R .250"	✓			
D .55"	±.030"	.556"	✓			
E 3.000"	±.010"	3.002"	✓			
F 3.750"	±.010"	3.749"	✓			
G 1.250"	±.010"	1.249"	✓			
H 5.000"	±.010"	4.998"	✓			
I Ø.500"		Ø.501"	✓			
J 1.500"	±.010"	1.499"	✓			
K 2.500"	±.010"	2.500"	✓			
L 6.000"	±.010"	5.995"	✓			
M 126.6	±.100"	126.6	✓			
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 07/08/16	Date: 01.08.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	